

Work Order ID ~~75149~~

October-18-11 10:11:04 AM

75149

Page 1

Item ID: D3805-041
 Revision ID:
 Item Name: Wearplate Assembly Fwd, Low Gear
 Start Date: 10/18/11 Start Qty: 4.00
 Required Date: 10/19/11 Req'd Qty: 4.00
 Reference: rework

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan:
 QC:

Date:
 Date:

Tooling:
 SPC (Y/N):

Date:
 Date:

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3805	B								
105		0.00							
105									
Small Fab									
Small Fab									
	Memo	0.00							
	PULL FROM STOCK								
	4 X D3805-041 B64573								
	REMOVE GASKET FROM WEARPLATE								
	KEEP IF GOOD TO RE-APPLY								
	3 D 3807-1								
	1 Scrap								
130	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
130									
Powdercoat									
Powder Coating									
	Memo	0.00							
	START TIME: 2:30								
	OVEN TEMPERATURE: 320°F								
	FINISH TIME: 3:00								
140	QC3- Inspect Part Finish	0.00							
140									
QC									
Quality Control									

SB 11/12/13

4X2 m/f 11/12/13

H 11-12-13

m 11/8/11

Work Order ID 75149

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75149

Page 2

Item ID: D3805-041
Revision ID:
Item Name: Wearplate Assembly Fwd, Low Gear
Start Date: 10/18/11 Start Qty: 4.00
Required Date: 10/19/11 Req'd Qty: 4.00
Reference: rework

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start ***NR1***
Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

150

0.00

150

Small Fab

Memo

0.00

Small Fab

1- Bond D3807-1 gasket to inner surface of wearplate using a thin layer of 3m
1300/1300L scotch grip adhesive as per dwg
BATCH: 11/19/11 592

11/21/14

(4)

160

0.00

160

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

8/12/14

(4)

170

0.00

170

Packaging

Packaging

Identify as per dwg & Stock Location: FR-1

Memo

0.00

x4 of del 11/21/14
counted & measured

Work Order ID 75149***75149***

Page 3

Item ID: D3805-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly Fwd, Low Gear

Start Date: 10/18/11 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/19/11 Req'd Qty: 4.00

4

Customer:

Reference: rework

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

180

QC21- Final Inspection - Work Order Release

0.00


180

QC

Memo

0.00

Quality Control

11/12/14 11-12-14
(4)

Picklist Print

October-18-11 10:09:40 AM

Page 1

Work Order ID: 75149

Parent Item: D3805-041

Start Date: 10/18/11

Required Date: 10/19/11

Parent Item Name: Wearplate Assembly Fwd, Low Gear

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:EC IPP Rev:B 09-03-04 rev.a as per dwg
DD verified by:EC IPP Rev:C 11.10.04 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3805-041		Manufactured	No				Each	16.0000		4			
Wearplate Assembly Fwd, Low Gear													

AS 12/12/14 (4)

Location	Loc Qty	Loc Code
FP	12	
73813	4	
74448	8	
FP002	4	
73814	2	
73815	2	

6/8 64573

D 3807-1

B69022

B75677

(3)

1

8

7

6

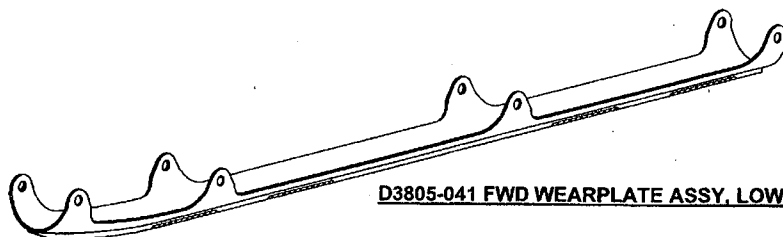
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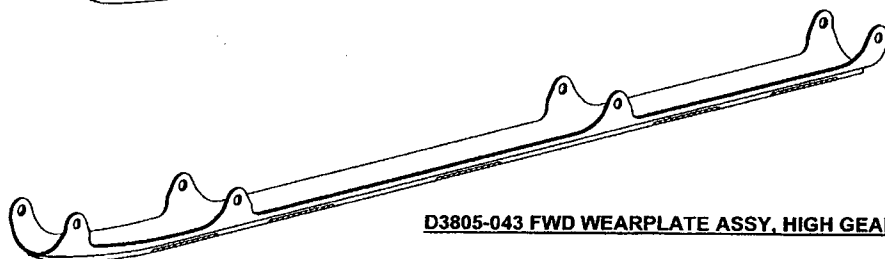
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2

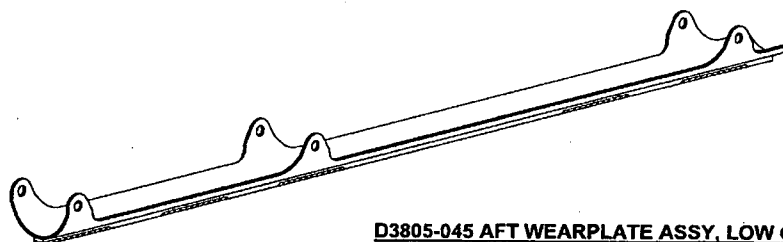
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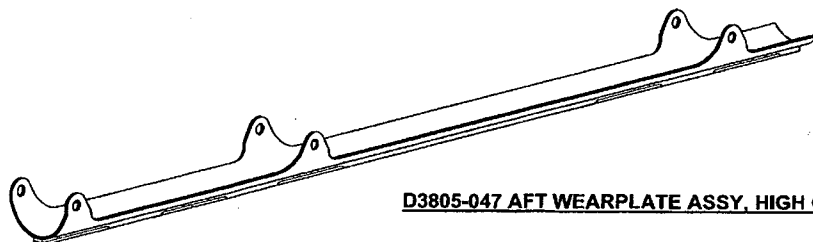
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR

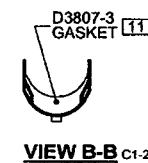
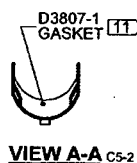
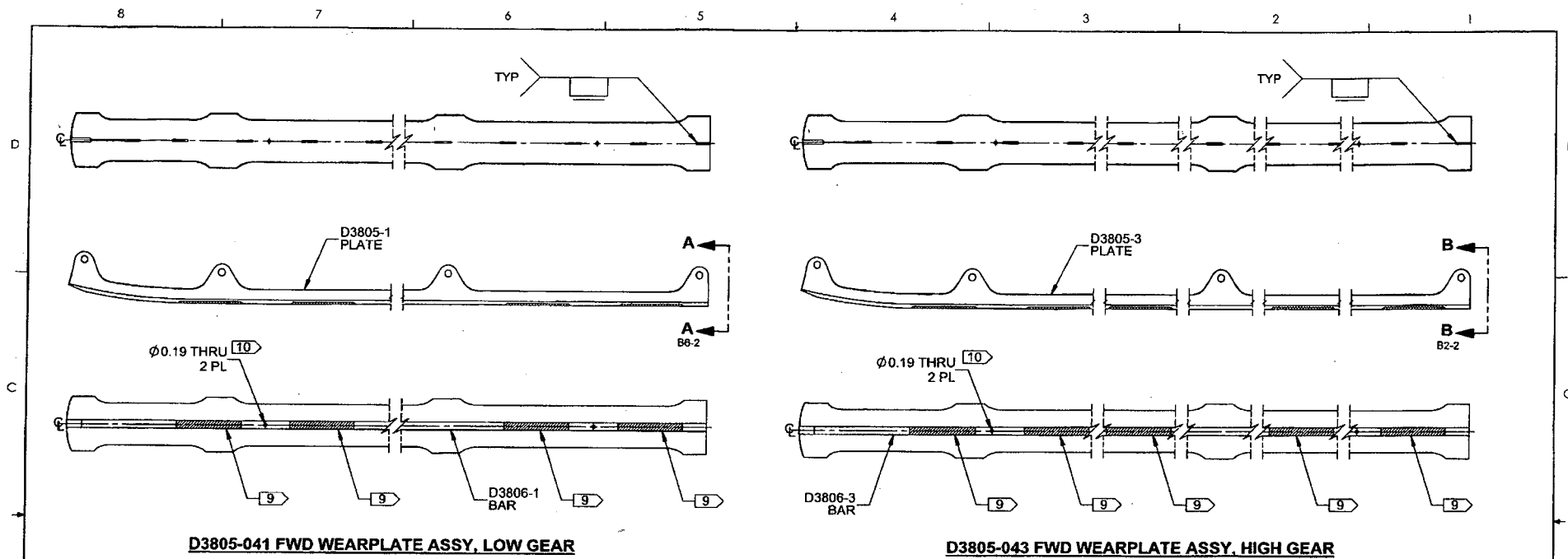


D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

RELEASED
2011-10-03
MD

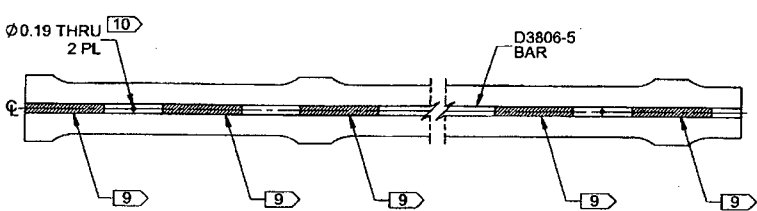
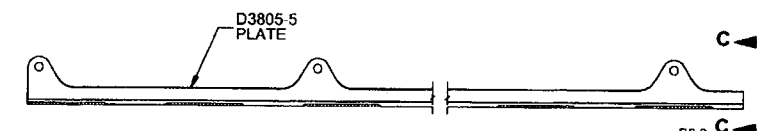
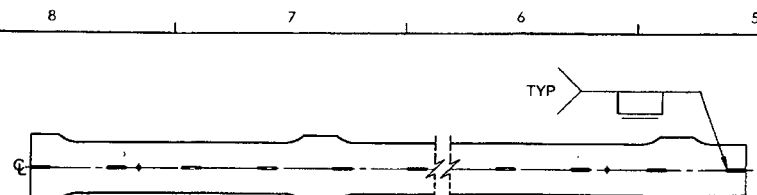
B	REVISED D3805-1F-3F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PAR11-106) AND RE-ORGANIZED NOTES SHEETS 2 & 3		MB	11.09.16
A	NEW ISSUE		MB	08.11.21
REV.	DESCRIPTION		BY	DATE
DESIGN	gk		DART AEROSPACE USA, INC.	
DRAWN	JP		KENT, WA	
CHECKED	M		DRAWING NO.	REV. B
MFG. APPR.	M		D3805	SHEET 1 OF 8
APPROVED	M		TITLE	SCALE
DE APPR.	M		WEARPLATE ASSY	NTS
DATE	11.09.16		COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



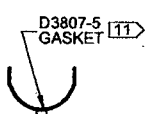
RELEASED
2011-10-03

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3805-041 = 4.18 lbs; D3805-043 = 4.78 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
 - 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
 - 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

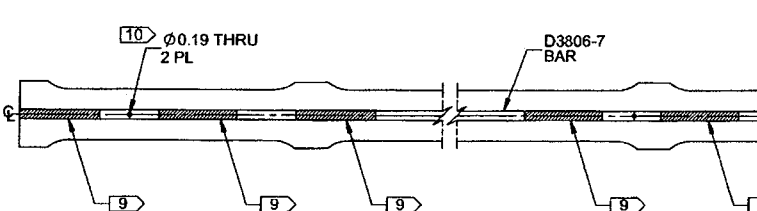
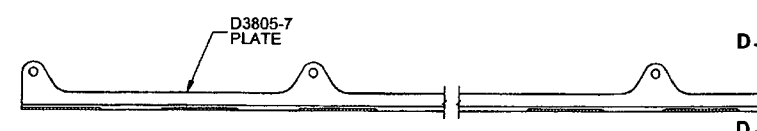
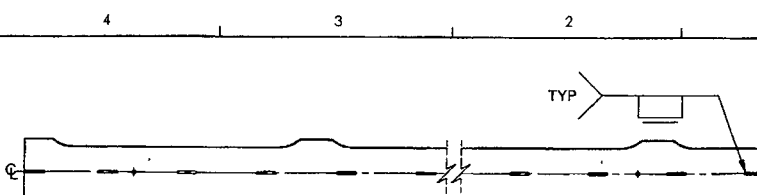
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D3805	REV. B
MFG. APPR.			SHEET 2 OF 8
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DE APPR.			NTS
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D3805-045 AFT WEARPLATE ASSY.



VIEW C-C C5-3



D3805-047 AFT WEARPLATE ASSY.

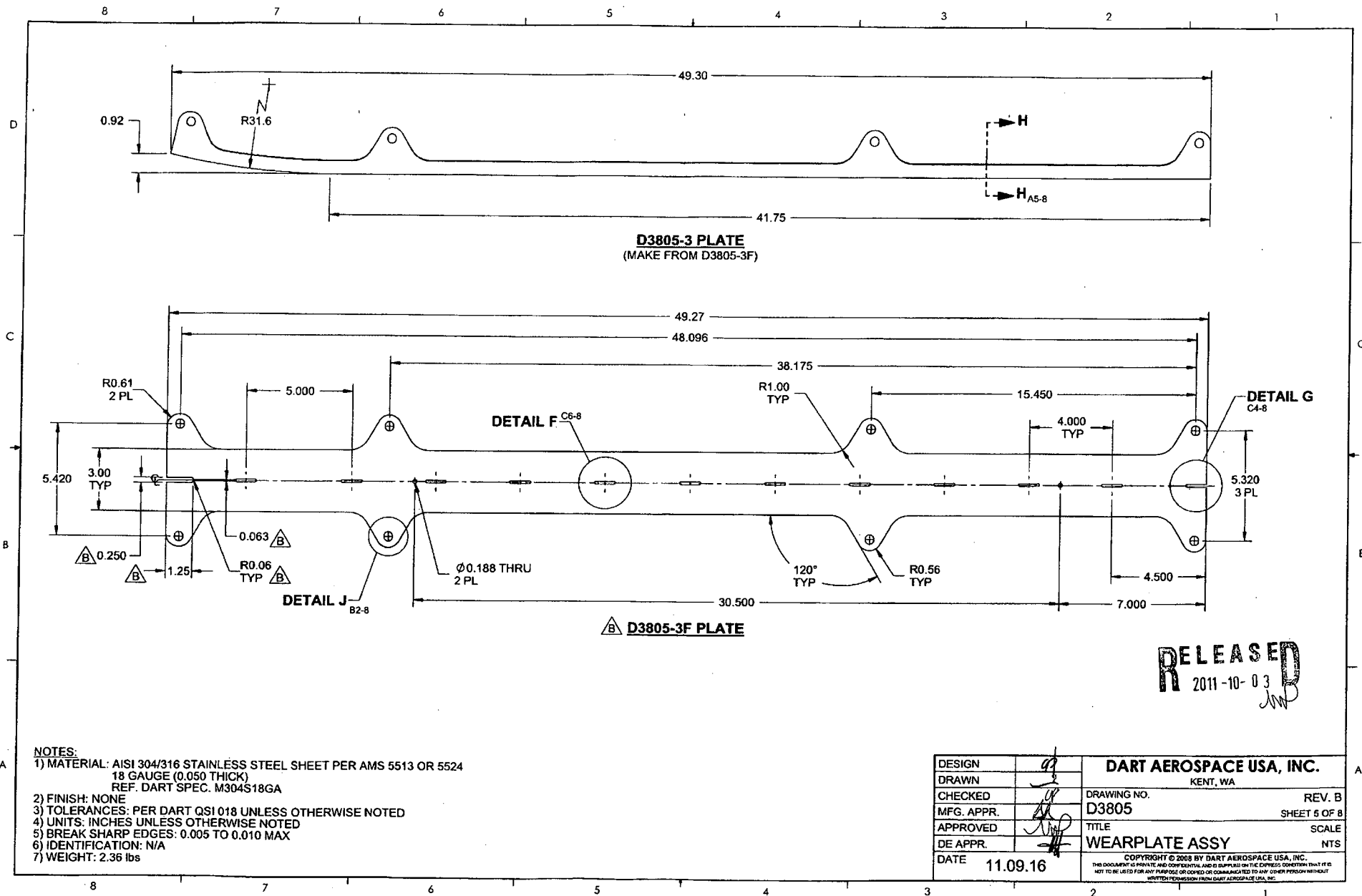


VIEW D-D C1-3

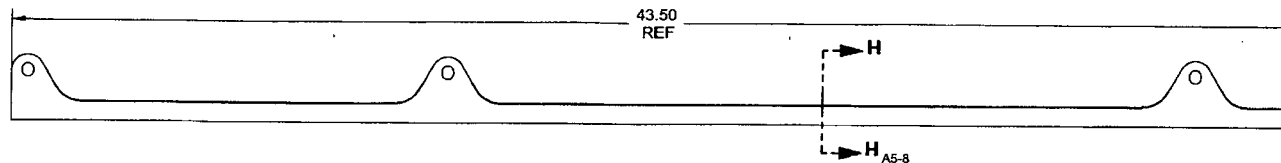
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3805-045 = 4.24 lbs; D3805-047 = 4.53 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
 - 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
 - 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

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MFG. APPR.		SHEET 3 OF 8	
APPROVED		TITLE WEARPLATE ASSY	SCALE
DE APPR.		NTS	
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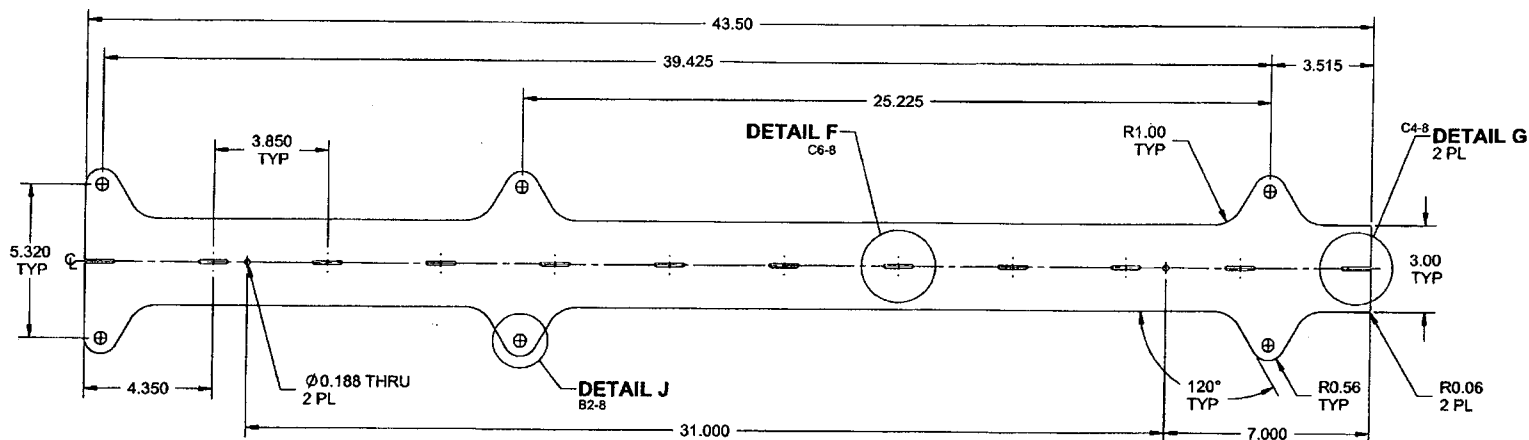
RELEASED
2011-10-03
JWP



8 7 6 5 4 3 2 1



D3805-5 PLATE
(MAKE FROM D3805-5F)



D3805-5F PLATE

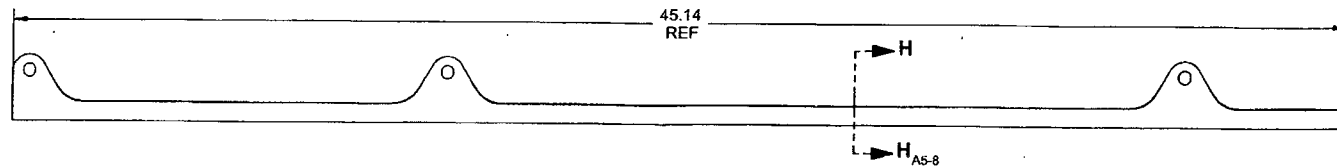
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2011-10-03

NOTES:

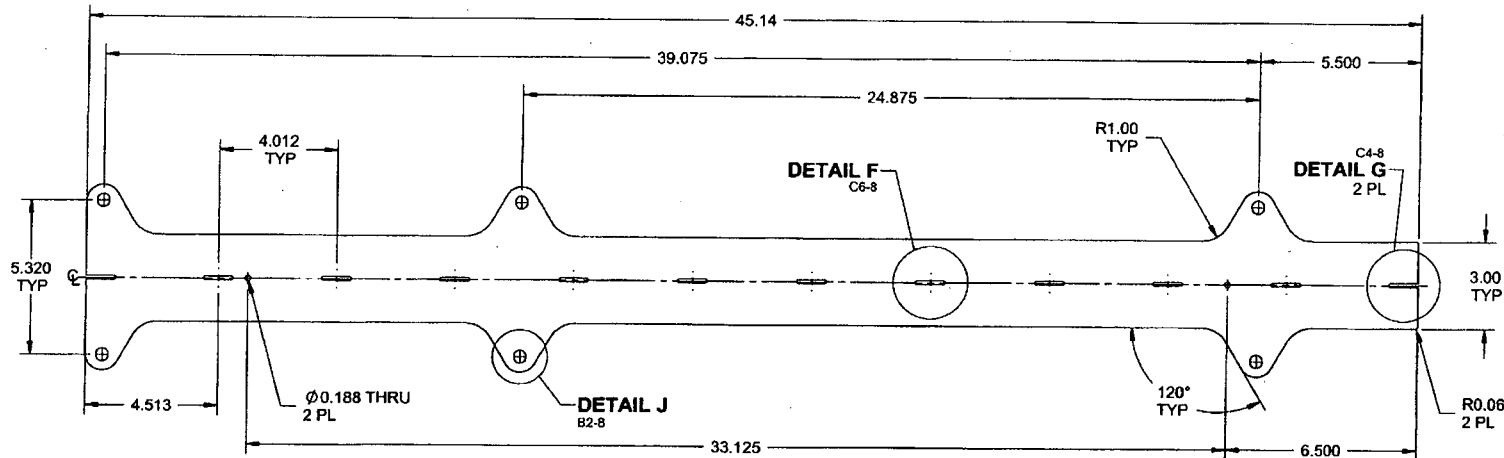
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

DESIGN	97	DART AEROSPACE USA, INC.	
DRAWN	97	KENT, WA	
CHECKED	97	DRAWING NO.	REV. B
MFG. APPR.	97	D3805	SHEET 6 OF 8
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8 7 6 5 4 3 2 1



D3805-7 PLATE
(MAKE FROM D3805-7F)



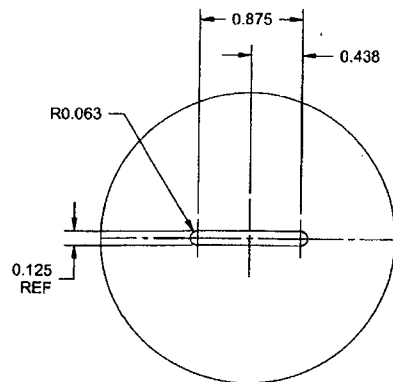
D3805-7F PLATE

RELEASED
2011-10-03

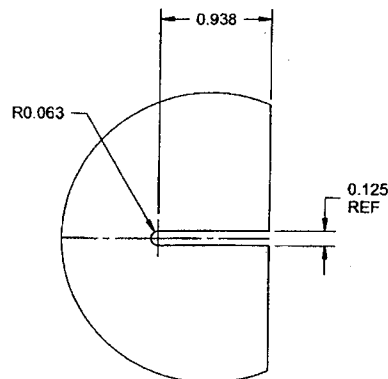
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

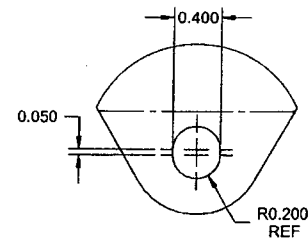
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DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3805	SHEET 7 OF 8
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DE APPR.		WEARPLATE ASSY	NTS
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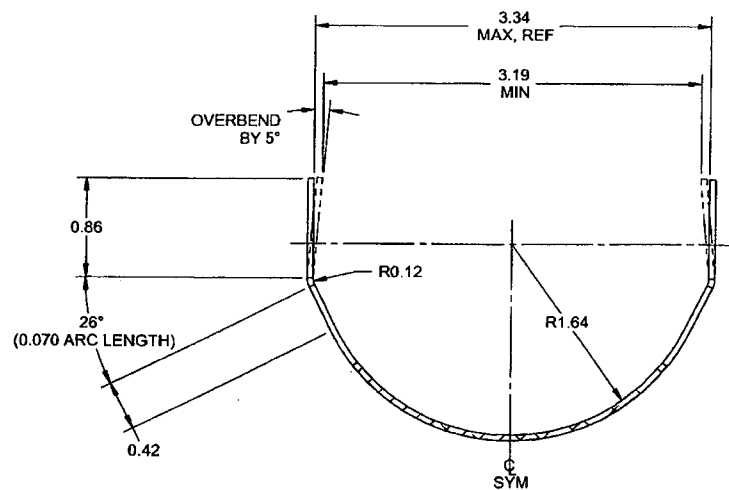
DETAIL F
SLOT DETAIL TYP
SCALE 4X
C5-4
C5-5
C4-6
C4-7



DETAIL G
SLOT DETAIL TYP
SCALE 4X
C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X
B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X
D3-4
D3-5
D3-6
D3-7

RELEASED
2011-10-03
WV

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D3805	REV. B
MFG. APPR.		SHEET 8 OF 8	
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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Picklist Print

Wednesday, December 08, 2010 10:29:08 AM

Page 1

Work Order ID: 64573

Parent Item: D3805-041

Parent Item Name: Wearplate Assembly Fv, Low Gear







Start Date: 12/8/2010

Required Date: 12/22/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:EC IPP Rev:B 09-03-04
rev.a as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3805-1  Plate		Manufactured	No			100	Each	0.0000	1	6			
				69023								EL 11-8-15	
D3806-1  Bar		Manufactured	No			100	Each	0.0000	1	6			
				70378x4 (Rev B) or prelm.								EL 11-8-15	
D3807-1  Gasket		Manufactured	No			150	Each	0.0000	1	6			
				B69022								SP 11/09/14	

POSITIVE RECALL

EFFECTIVE 11.10.10 AUTH h

RELEASED h DATE 11.10.10

11.10.10 LIN 11.640

PULLED ON W/O B75199 TO CONFIRM/REWORK
TO REV B.